



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D3913-041**  
**Job Sheet 211928**



**Part No:** D3913-041

**Job Qty:** 1 pcs

**Part Name:** Long Basket Base Assembly, 350



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 7/31/20

**Job Tracking No:**

**Created By:** Marie Lajeunesse

**Due Date:** 9/4/20

**Description:** SIOP

**Type:** Stock

**Note:** DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier      |           | Sign-off                 |
|-------|------------------------|-------|------------|----------|-----------|---------|--------------------------|-----------|--------------------------|
|       |                        |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier    | Lead Time |                          |
| 100   | Large Fab - Basket - 1 | 1 pcs | 9/3/20     |          | 0.00      | 19.61   | Large Fab - 1            |           | SEP 08 2020              |
|       |                        |       |            |          |           |         | Large Fab - 10           |           |                          |
|       |                        |       |            |          |           |         | Large Fab - 2            |           |                          |
|       |                        |       |            |          |           |         | Large Fab - 3            | DAS       |                          |
|       |                        |       |            |          |           |         | Large Fab - 4            | 24        |                          |
|       |                        |       |            |          |           |         | Large Fab - 5            | 9-89      |                          |
|       |                        |       |            |          |           |         | Large Fab - 6            |           |                          |
|       |                        |       |            |          |           |         | Large Fab - 7            |           |                          |
|       |                        |       |            |          |           |         | Large Fab - 8            |           |                          |
|       |                        |       |            |          |           |         | Large Fab - 9            |           |                          |
|       |                        |       |            |          |           |         | Large Fab - 11 (Various) |           |                          |
|       |                        |       |            |          |           |         | Large Fab - 12           |           |                          |
| 110   | QC 9                   | 1 pcs | 9/3/20     |          | 0.00      | 0.00    | QC 9 - 10                |           | DAS<br>50 9-7-20<br>9-89 |
|       |                        |       |            |          |           |         | QC 9 - 18                |           |                          |
|       |                        |       |            |          |           |         | QC 9 - 24                |           |                          |
|       |                        |       |            |          |           |         | QC 9 - 43                |           |                          |
|       |                        |       |            |          |           |         | QC 9 - 50                |           |                          |
|       |                        |       |            |          |           |         | QC 9 - 9                 |           |                          |
| 120   | QC 5                   | 1 pcs | 9/3/20     |          | 0.00      | 0.00    | QC 5 - 10                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 12                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 17                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 18                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 19                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 22                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 24                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 3                 |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 43                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 49                |           |                          |
|       |                        |       |            |          |           |         | QC 5 - 51                |           |                          |



DART Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Container No:** S299086



**Part:** D3913-041

**Job No:** 211928

**Serial No/Batch:** S299086

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions:** Various STC's

Date: 09/08/20

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|                                     |       |        |      |      |                           |          |             |
|-------------------------------------|-------|--------|------|------|---------------------------|----------|-------------|
|                                     |       |        |      |      | QC 5 - 58                 |          |             |
|                                     |       |        |      |      | QC 5 - 68                 |          |             |
|                                     |       |        |      |      | QC 5 - 9                  | DAS      |             |
|                                     |       |        |      |      | QC 5 - 50                 | 50       | 9-9-20      |
|                                     |       |        |      |      | QC 5 - 30                 | 9-89     |             |
|                                     |       |        |      |      | QC 5 - 40                 |          |             |
|                                     |       |        |      |      | QC 5 - 61                 |          |             |
|                                     |       |        |      |      | QC 5 - 81                 |          |             |
|                                     |       |        |      |      | QC 5 - 82                 |          |             |
| 125 Handfinish - 2-1 Pressure- B4B  | 1 pcs | 9/3/20 | 0.00 | 0.29 | Handfinish - 2 - 1 - B4B  | 20-09-9. | DAS 34 9-89 |
|                                     |       |        |      |      | Handfinish - 2 - 2 - B4B  |          |             |
|                                     |       |        |      |      | Handfinish - 2 - 3 - B4B  |          |             |
|                                     |       |        |      |      | Handfinish - 2 - 4 - B4B  |          |             |
| 130 Powdercoat - 2 White Gl(S)- B4B | 1 pcs | 9/3/20 | 0.00 | 0.93 | Powdercoat - 1 - B4B      |          |             |
|                                     |       |        |      |      | Powdercoat - 2 - B4B      |          |             |
|                                     |       |        |      |      | Powdercoat - 3 - B4B      | 20-09-9. | DAS 34 9-89 |
|                                     |       |        |      |      | Powdercoat - 4 - B4B      |          |             |
|                                     |       |        |      |      | Powdercoat - 5 - B4B      |          |             |
|                                     |       |        |      |      | Powdercoat - 6 - B4B      |          |             |
|                                     |       |        |      |      | Powdercoat - 7 - B4B      |          |             |
|                                     |       |        |      |      | Powdercoat - 8 - B4B      |          |             |
|                                     |       |        |      |      | Powdercoat - 9 - B4B      |          |             |
|                                     |       |        |      |      | Powdercoat - 10 - B4B     |          |             |
| 140 QC 3                            | 1 pcs | 9/3/20 | 0.00 | 0.00 | QC 3 - 10                 |          |             |
|                                     |       |        |      |      | QC 3 - 13                 |          |             |
|                                     |       |        |      |      | QC 3 - 15                 | 20-9-16  | DAS 15 9-89 |
|                                     |       |        |      |      | QC 3 - 17                 |          |             |
|                                     |       |        |      |      | QC 3 - 18                 |          |             |
|                                     |       |        |      |      | QC 3 - 2                  |          |             |
|                                     |       |        |      |      | QC 3 - 28                 |          |             |
|                                     |       |        |      |      | QC 3 - 3                  |          |             |
|                                     |       |        |      |      | QC 3 - 30                 |          |             |
|                                     |       |        |      |      | QC 3 - 34                 |          |             |
|                                     |       |        |      |      | QC 3 - 36                 |          |             |
|                                     |       |        |      |      | QC 3 - 41                 |          |             |
|                                     |       |        |      |      | QC 3 - 51                 |          |             |
|                                     |       |        |      |      | QC 3 - 58                 |          |             |
|                                     |       |        |      |      | QC 3 - 59                 |          |             |
|                                     |       |        |      |      | QC 3 - 68                 |          |             |
|                                     |       |        |      |      | QC 3 - 9                  |          |             |
|                                     |       |        |      |      | QC 3 - 40                 |          |             |
|                                     |       |        |      |      | QC 3 - 19                 |          |             |
|                                     |       |        |      |      | QC 3 - 43                 |          |             |
|                                     |       |        |      |      | QC 3 - 24                 |          |             |
|                                     |       |        |      |      | QC 3 - 61                 |          |             |
|                                     |       |        |      |      | QC 3 - 81                 |          |             |
|                                     |       |        |      |      | QC 3 - 82                 |          |             |
|                                     |       |        |      |      | QC 3 - 87                 |          |             |
| 150 Handfinish - 4-1-Assembly- B4B  | 1 pcs | 9/4/20 | 0.00 | 0.50 | Handfinish - 4 - 1 - B4B  |          |             |
|                                     |       |        |      |      | Handfinish - 4 - 10 - B4B |          |             |
|                                     |       |        |      |      | Handfinish - 4 - 11 - B4B |          |             |
|                                     |       |        |      |      | Handfinish - 4 - 12 - B4B |          |             |
|                                     |       |        |      |      | Handfinish - 4 - 13 - B4B |          |             |
|                                     |       |        |      |      | Handfinish - 4 - 14 - B4B |          |             |
|                                     |       |        |      |      | Handfinish - 4 - 15 -     |          |             |



[https://www.plexonline.com/badd2c15-9956-4a4c-967a-840fa25fceb3/Plexus\\_Control/Report\\_View\\_2.asp?URL=../Part/Job\\_Sheet.asp&Report=Tru...](https://www.plexonline.com/badd2c15-9956-4a4c-967a-840fa25fceb3/Plexus_Control/Report_View_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru...) 3/5



|                |          |        |           |                        |  |
|----------------|----------|--------|-----------|------------------------|--|
| 180 QC 21 - SA | 1<br>pcs | 9/4/20 | 0.00 0.00 | Packaging 3 - 31 - B4B |  |
|                |          |        |           | Packaging 3 - 32 - B4B |  |
|                |          |        |           | Packaging 3 - 33 - B4B |  |
|                |          |        |           | Packaging 3 - 34 - B4B |  |
|                |          |        |           | Packaging 3 - 35 - B4B |  |
|                |          |        |           | Packaging 3 - 36 - B4B |  |
|                |          |        |           | Packaging 3 - 37 - B4B |  |
|                |          |        |           | QC 21 - SA - 21        |  |
|                |          |        |           | QC 21 - SA - 70        |  |
|                |          |        |           | QC 21 - SA - 9         |  |
|                |          |        |           | QC 21 - SA - 77        |  |

Part Op 100 - Weld per dwg A/R S.S. rod Batch 139061 1- assemble ribs , weld as per dwg D3913 using 819610A \*\*\*inspect  
 Descriptions: before welding mesh\*\*\* 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to  
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913  
 \*\*\*take lid to locate hinge and bracket\*\*\* 4- Weld D4672-1 blanking plates as per dwg  
 110 - QC9- Inspect visual per QSI004- Fusion Welds  
 120 - QC5- Inspect part completeness to step on W/O  
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings  
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder  
 coat  
 140 - QC3- Inspect Part Finish  
 150 - Assemble as per dwg - Pick Kit  
 160 - QC5- Inspect part completeness to step on W/O  
 170 - Identify as per dwg & Stock Location:  
 180 - QC21- Final Inspection - Work Order Release

## Job BOM

| Part / Item    | Component Name         | Quantity      | Operation                         | Container         |
|----------------|------------------------|---------------|-----------------------------------|-------------------|
| D2581          | Mounting Bracket       | 2 pcs (2 ea)  | 100-Large Fab - Basket - 1        | 5291266           |
| D3913-1        | Rib                    | 1 pcs (1 ea)  | 100-Large Fab - Basket - 1        | 5266446           |
| D3913-15       | Wide Handle Plate      | 1 pcs (1 ea)  | 100-Large Fab - Basket - 1        | 5267768           |
| D3913-3        | Rib                    | 1 pcs (1 ea)  | 100-Large Fab - Basket - 1        | 5266451           |
| D3913-7        | Rib                    | 2 pcs (2 ea)  | 100-Large Fab - Basket - 1        | 5255994           |
| D3913-9        | Hinge Rib              | 1 pcs (1 ea)  | 100-Large Fab - Basket - 1        | 5266454           |
| D3916-041      | Rib Assembly           | 2 pcs (2 ea)  | 100-Large Fab - Basket - 1        | 5297556           |
| D3916-5        | Light Rib              | 3 pcs (3 ea)  | 100-Large Fab - Basket - 1        | 5284204 - 5297570 |
| D4016-1        | Hinge Half, Base       | 3 pcs (3 ea)  | 100-Large Fab - Basket - 1        | 5242495 297 681   |
| D4017-7        | Rib                    | 3 pcs (3 ea)  | 100-Large Fab - Basket - 1        | 5248314           |
| D4017-9        | Rib                    | 2 pcs (2 ea)  | 100-Large Fab - Basket - 1        | 5266159           |
| D4020-11       | End Mesh, Basket       | 2 pcs (2 ea)  | 100-Large Fab - Basket - 1        | 5287645           |
| D4021-1        | Handle Plate           | 3 pcs (3 ea)  | 100-Large Fab - Basket - 1        | 5253605           |
| D4034-041      | Aft Upper Rib Assembly | 1 pcs (1 ea)  | 100-Large Fab - Basket - 1        | 5267852           |
| D4034-043      | Fwd Upper Rib Assembly | 1 pcs (1 ea)  | 100-Large Fab - Basket - 1        | 5295861           |
| D4672-1        | Blanking Plate         | 2 pcs (2 ea)  | 100-Large Fab - Basket - 1        | 5256099           |
| M304EX0.75-16F | Expanded Metal Flat SS | 32 sf (32 ea) | 100-Large Fab - Basket - 1        | 5256252           |
| AN3-10A        | BOLT 5249345 (x5)      | 6 Ea (6 ea)   | 150-Handfinish - 4-1-Assembly-B4B | 5253416-1         |
| D2931          | Bumper                 | 2 pcs (2 ea)  | 150-Handfinish - 4-1-Assembly-B4B | 526435            |
| MS20600-AD4W3  | Cherry Rivet           | 2 Ea (2 ea)   | 150-Handfinish - 4-1-Assembly-B4B | 5233855           |
| MS21042L3      | Nut                    | 6 Ea (6 ea)   | 150-Handfinish - 4-1-Assembly-B4B | 524415-1          |
| NAS1149F0332P  | Washer (AN960-10L)     | 12 Ea (12 ea) | 150-Handfinish - 4-1-Assembly-B4B | 5215387           |
| D4021-5        | Blanking Plate         | 2 pcs (2 ea)  | 150-Handfinish - 4-1-Assembly-B4B | 5241406           |
| NAS1149FN832P  | Washer (AN960-8)       | 2 Ea (2 ea)   | 150-Handfinish - 4-1-Assembly-B4B | 5136366           |

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 100-Large Fab - Basket - 1         | D2581          | 2        | 26        | 0         |
|                                    | D3913-1        | 1        | 6         | 0         |
|                                    | D3913-15       | 1        | 20        | 0         |
|                                    | D3913-3        | 1        | 6         | 0         |
|                                    | D3913-7        | 2        | 12        | 0         |
|                                    | D3913-9        | 1        | 7         | 0         |
|                                    | D3916-041      | 2        | 0         | 0         |
|                                    | D3916-5        | 3        | 3         | 0         |
|                                    | D4016-1        | 3        | 27        | 0         |
|                                    | D4017-7        | 3        | 45        | 0         |
|                                    | D4017-9        | 2        | 6         | 0         |
|                                    | D4020-11       | 2        | 2         | 0         |
|                                    | D4021-1        | 3        | 18        | 0         |
|                                    | D4034-041      | 1        | 2         | 0         |
|                                    | D4034-043      | 1        | 0         | 0         |
|                                    | D4672-1        | 2        | 34        | 0         |
|                                    | M304EX0.75-16F | 32       | 838       | 0         |
| 150-Handfinish - 4-1-Assembly-B4B  | AN3-10A        | 6        | 190       | 0         |
|                                    | D2931          | 2        | 457       | 0         |
|                                    | D4021-5        | 2        | 8         | 0         |
|                                    | MS20600-AD4W3  | 2        | 311       | 0         |
|                                    | MS21042L3      | 6        | 969       | 0         |
|                                    | NAS1149F0332P  | 12       | 1,747     | 0         |
|                                    | NAS1149FN832P  | 2        | 1,177     | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |